

shg Feb. 17

Work Order ID 79277

79277

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January-24-12 12:54:57 PM

Item ID: D4055-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 1/24/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/17/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4055	B								

100 Weld per dwg A/R Aluminum rod Batch: 11978 0.00

100

Large Fab

Large Fab

Memo

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

12.02.10 - 1 ϕ

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Item ID: D4055-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 1/24/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/17/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00				1	0		BE12/02/13
110									
QC	Memo	0.00							
Quality Control									
121	Weld per dwg A/R Aluminum rod Batch: 119785	0.00							
121									
Large Fab	Memo	0.00							
Large Fab	1-Weld top D4055-1								
122	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
122									
QC	Memo	0.00							
Quality Control									

112.02.14 1 0

1 0 BE12/02/14

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Item ID:	D4055-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Fuel Tank Assembly				Stop	*NS2*
Start Date:	1/24/12	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	2/17/12	Req'd Qty:	1.00	*1*	Customer:	
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

1 BR 12.2.15.

1XØ m/ 12/02/15

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Item ID: D4055-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 1/24/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/17/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3	0.00							
170	AP1601 P	0.00							1X OK M/L 12/02/15
Powdercoat	Memo								
Powder Coating	8/12/15 ***Mask prior to powdercoat*** Start Time: 1:30 Oven Temperature: 320°F Finish Time: 2:00								
180	QC3- Inspect Part Finish	0.00							
180									1 BL 12.2.15.
QC	Memo	0.00							
Quality Control									
185		0.00							
185									
SprayPaint	Memo	0.00							
Spray Painting	Seal inside of tank using Sloshing PR-1005-L Scaler as per dwg								

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Item ID: D4055-041
Revision ID:
Item Name: Fuel Tank Assembly

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/24/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/17/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0.00

190

0.00

Small Fab

Memo

Small Fab

Assemble as per dwg & DSI 9577

200

QC5- Inspect part completeness to step on W/O

0.00

200

0.00

QC

Memo

Quality Control

220

QC5- Inspect part completeness to step on W/O

0.00

220

0.00

QC

Memo

Quality Control

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Work Order ID: 79277

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B 10.05.17 ECN10-562
DD verf:EC IPP Rev C: 10.11.23 revised pick list EC verified by:DD
IPP Rev D: 11.06.01 per D4055 revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No			190	Each	0.0000	1	1		3/7/11	
D3997-5 Placard		Manufactured	No			190	Each	7.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		97							
				72611		94							
				73507		3							
D3997-11 Placard		Manufactured	No			190	Each	6.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		6							
				73510		6							
D3997-17 Placard		Manufactured	No			190	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		7							
				73513		7							
D3997-29 Placard		Manufactured	No			190	Each	8.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		8							
				73511		8							
D3997-43 Placard		Manufactured	No			190	Each	6.0000	1	1		12/2/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST104		6							
				73512		6							

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Work Order ID: 79277
Parent Item: D4055-041
Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

D3999-7 Corner Manufactured No 100 Each 15.0000 1 1 *12.02.10*

Location	Loc Qty	Loc Code
WA014	15	
71695	1	
75156	14	

D3999-9 Angle Manufactured No 100 Each 6.0000 1 1 *12.02.09*

Location	Loc Qty	Loc Code
WA014	6	
71696	6	

D3999-11 Earth Tab Manufactured No 100 Each 8.0000 1 1 *12.02.09*

Location	Loc Qty	Loc Code
WA	8	
WA013	-8	
WA014	8	
75180	8	

D3999-041 Baffle Assembly, Aft Manufactured No 100 Each 5.0000 1 1 *12.02.09*

Location	Loc Qty	Loc Code
WA014	5	
72653	1	
75230	4	

D3999-043 Baffle Assembly, Fwd Manufactured No 100 Each 2.0000 1 1 *12.02.09*

Location	Loc Qty	Loc Code
WA014 <i>378814</i>	2	
74961	2	

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Work Order ID: 79277

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

D4000-1
Fuel Supply Fitting

Manufactured No

100 Each 3.0000

1

1

12.02.09

Location

Loc Qty

Loc Code

WA014

3

1

74835

3

1

D4000-5
Fuel Tank Vent Fitting

Manufactured No

100 Each 3.0000

1

1

12.02.09

Location

Loc Qty

Loc Code

WA014

3

1

74833

3

1

D4000-9
Grommet

Manufactured No

100 Each 24.0000

3

3

12.02.09

Location

Loc Qty

Loc Code

WA013

24

3

78379

24

3

D4000-043
Drain Fitting Assembly, Fwd

Manufactured No

100 Each 5.0000

1

1

12.02.09

Location

Loc Qty

Loc Code

WA

5

1

75225

1

1

78181

2

1

78732

2

1

D4000-045
Fuel Pickup Fitting Assembly

Manufactured No

100 Each 5.0000

1

1

12.02.09

Location

Loc Qty

Loc Code

WA

2

1

78756

2

1

WA013

1

1

72078

1

1

WA014

2

1

71669

1

1

78266

1

1

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Work Order ID: 79277

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

D4000-041 Manufactured No 100 Each 3.0000 1 1 12.02.09
Drain Fitting Assembly, Aft

Location	Loc Qty	Loc Code
WA	3	
75232	1	
78182	2	

D4001-1 Manufactured No 100 Each 3.0000 1 1 12.02.10
Fitting

Location	Loc Qty	Loc Code
WA014	3	
74831	3	

D4008-11 Manufactured No 100 Each 4.0000 1 1 12.02.09
Hinge Half

Location	Loc Qty	Loc Code
WA014	4	
75228	4	

D4008-041 Manufactured No 190 Each 5.0000 1 1 12.02.09
Fuel Filler Splash Guard Assembly

Location	Loc Qty	Loc Code
ST108	5	
72792	5	

D4023-3 Manufactured No 100 Each 7.0000 1 1 12.02.09
Cap and Flange

Location	Loc Qty	Loc Code
ST110	7	
73514	7	

D4025-1 Manufactured No 100 Each 4.0000 1 1 12/2/12
Fuel Quantity Sender

Location	Loc Qty	Loc Code
ST141a	4	
71765	3	
72257	1	

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Work Order ID: 79277
Parent Item: D4055-041
Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

D4055-11 Tank Front and Bottom Manufactured No 100 Each 5.0000 1 1 12.02.09

Location Loc Qty Loc Code

WA014 5

74908 5

D4055-9 Tank Back Manufactured No 100 Each 4.0000 1 1 12.02.10

Location Loc Qty Loc Code

WA014 4

75125 4

D4055-7 Tank Fwd End Manufactured No 100 Each 6.0000 1 1 12.02.10

Location Loc Qty Loc Code

WA014 B73441 6

73476 4

74955 2

D4055-5 Tank Upper Cut Out Manufactured No 100 Each 5.0000 1 1 12.02.10

Location Loc Qty Loc Code

WA014 B73476 5

74907 5

D4055-3 Tank Aft End Manufactured No 100 Each 6.0000 1 1 12.02.10

Location Loc Qty Loc Code

WA014 6

73475 2

75224 4

D4055-1 Tank Top Manufactured No 100 Each 1.0000 1 1 12.02.10

Location Loc Qty Loc Code

WA014 B78380 1

71701 1

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Work Order ID: 79277

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

D4057-1
Retaining Ring

Manufactured No

100 Each 20.0000

3

3

12.02.09

Location

Loc Qty

Loc Code

WA013

20

71166

20

AN3H5A
Bolt

Purchased No

190 Each 17.0000

5

5

Location

Loc Qty

Loc Code

ST351

17

116704

1

118112

16

NAS1149D0363J
Washer

Purchased No

190 Each 3,670.0000

5

5

1117565

Location

Loc Qty

Loc Code

ST298

3670

117601

61

118077

1

118612

18

119537

1041

120142

1549

120308

1000

D4404-1
Cushion

Manufactured No

190 Each 8.0000

1

1

Location

Loc Qty

Loc Code

ST242A

8

75181

7

76569

1

D4404-5
Cushion, Fwd

Manufactured No

Each 5.0000

Location

Loc Qty

Loc Code

ST242A

5

76899

5

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Work Order ID: 79277

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 1/24/12

Required Date: 2/17/12

Start Qty: 1.00

Required Qty: 1.00

D4404-7
Cushion, Upper Side

Manufactured No

Each 7.0000

1

Location

Loc Qty

Loc Code

ST242A

7

79119

7

D4404-9
Cushion, Lower Side

Manufactured No

Each 7.0000

Location

Loc Qty

Loc Code

ST

-1

79120

7

ST242B

8

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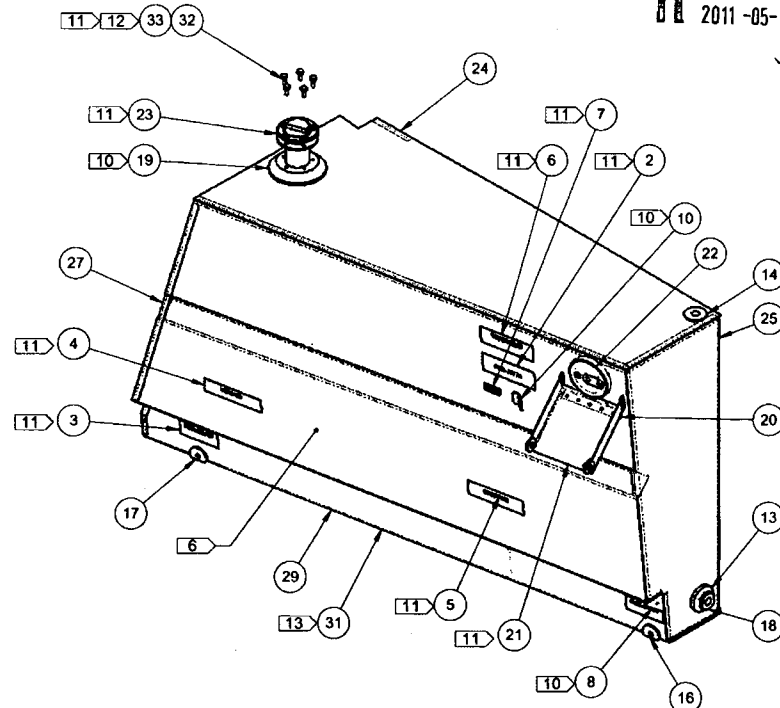
Page 7

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

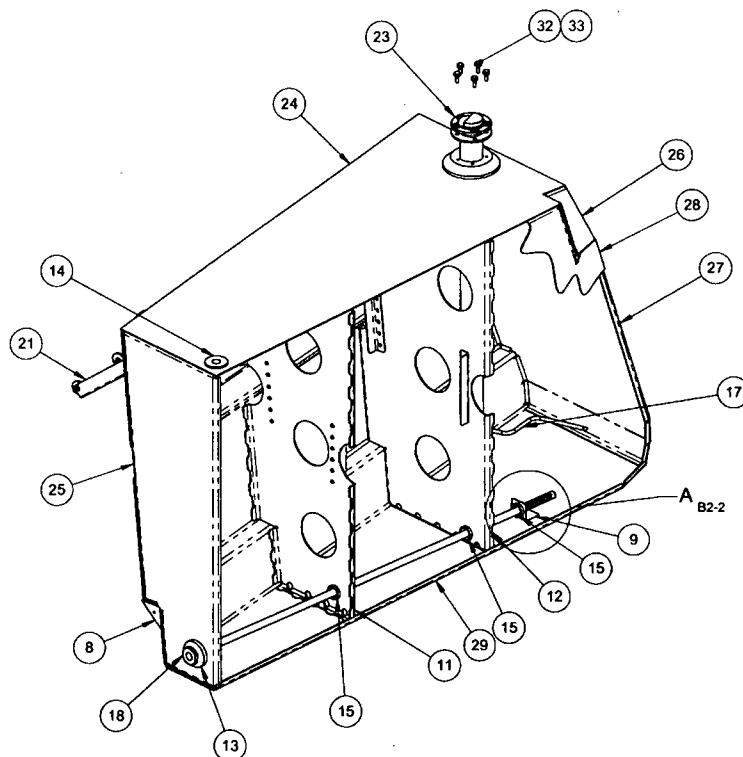
D4055-041 FUEL TANK ASSEMBLY



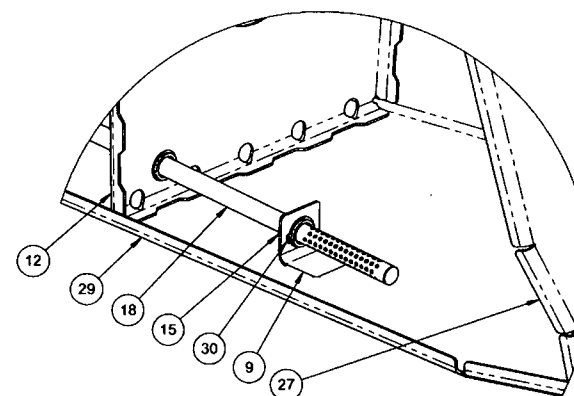
B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	11.05.12
A	NEW ISSUE	HS 10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.05.12	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B
TITLE TANK	SHEET 1 OF 15
SCALE	NTS
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2011-05-30



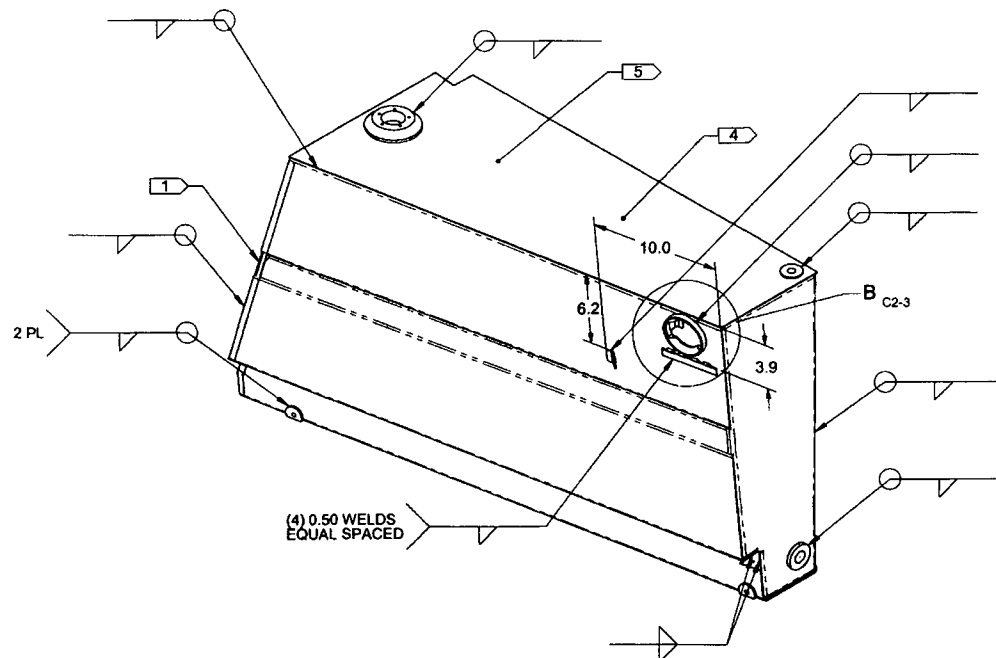
D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



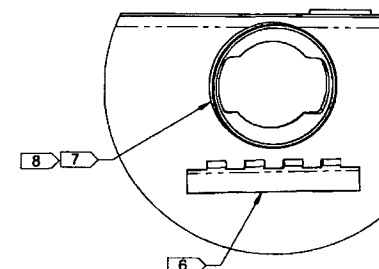
DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

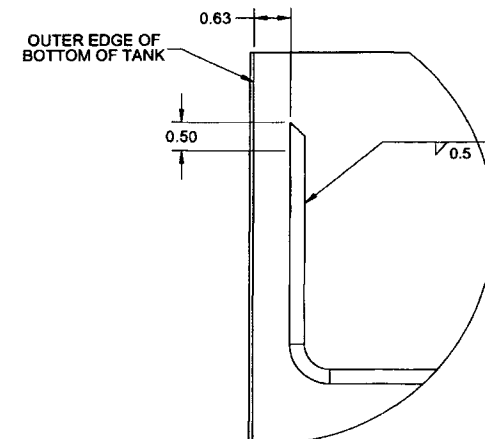
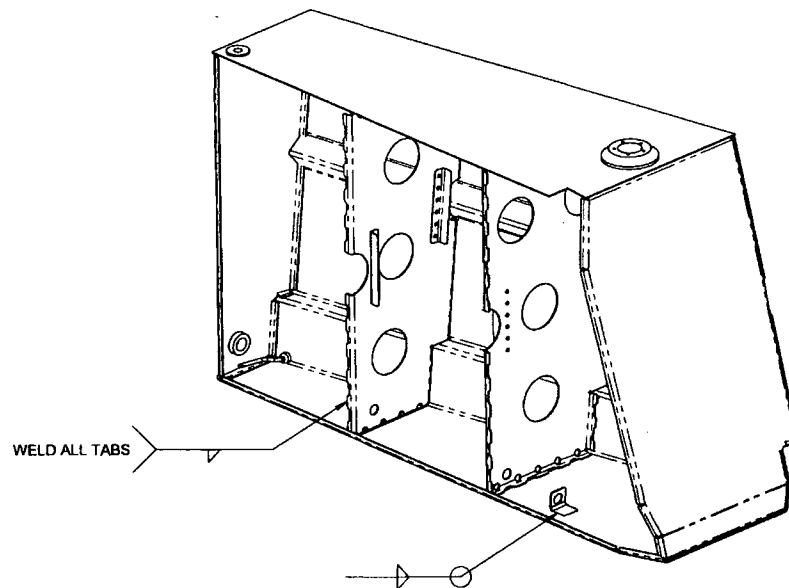
C4-3

RELEASED
2011-05-30
M

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.80 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

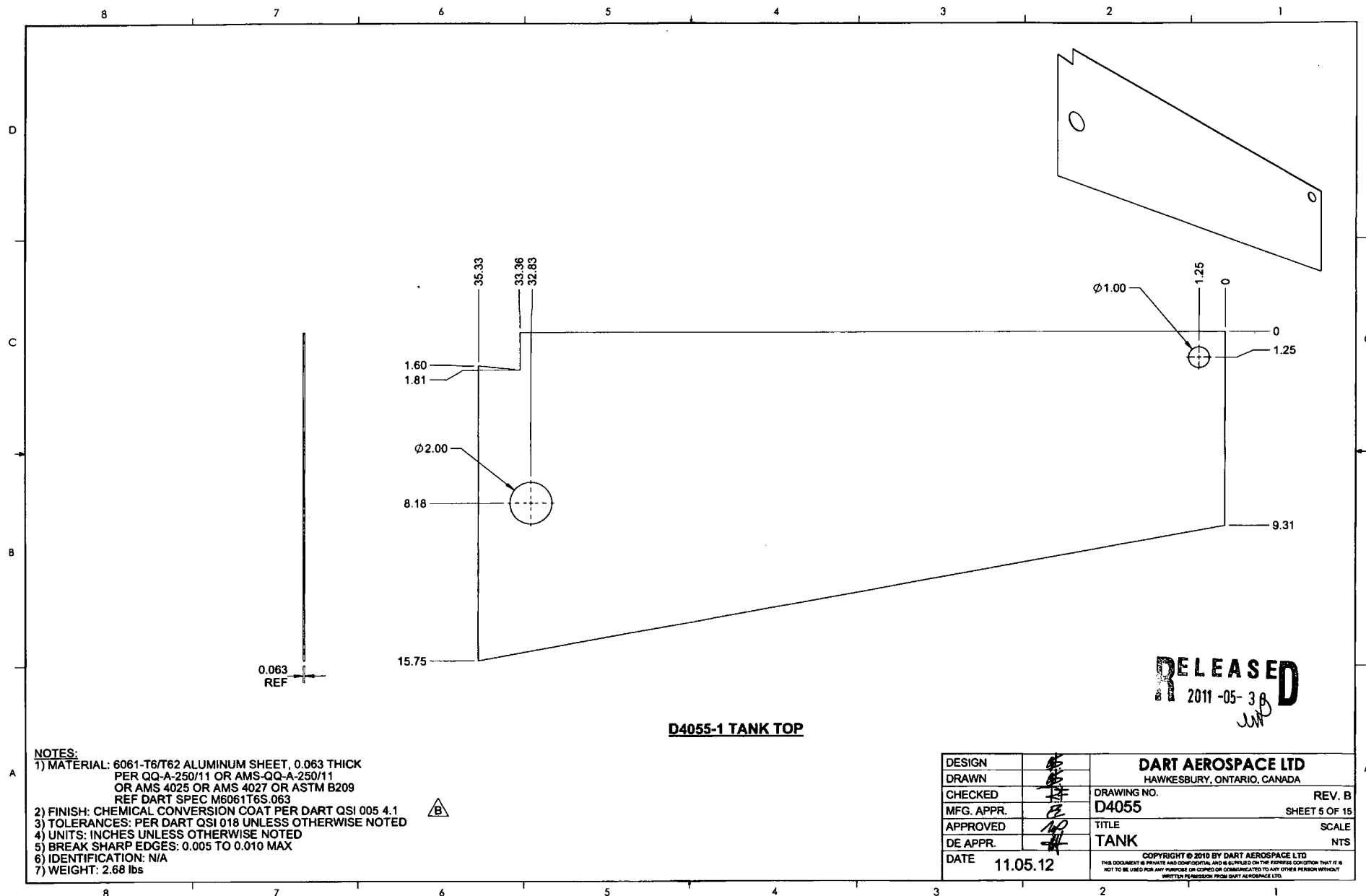


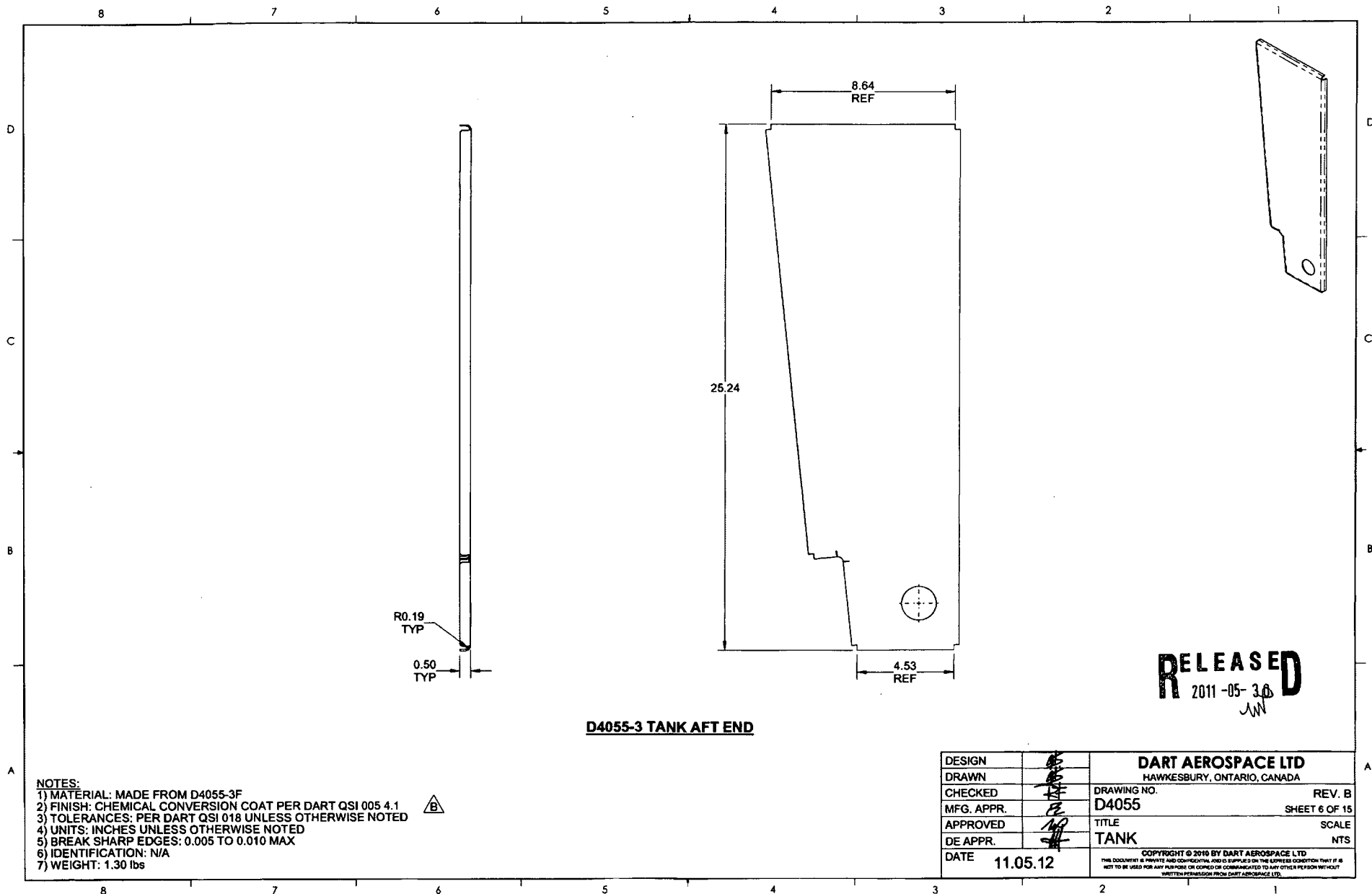
DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

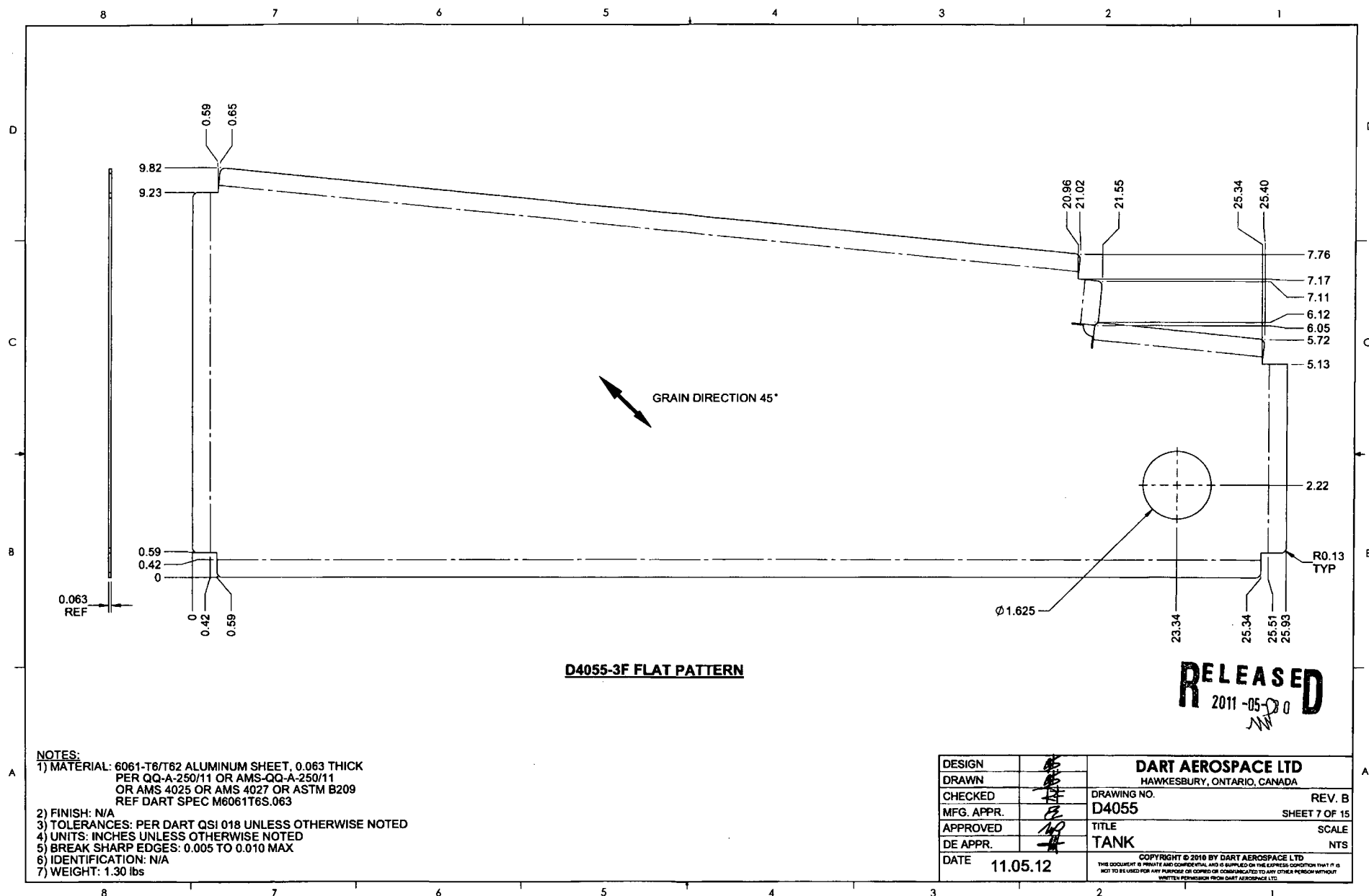
D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

RELEASED
 2011-05-30
 JWW

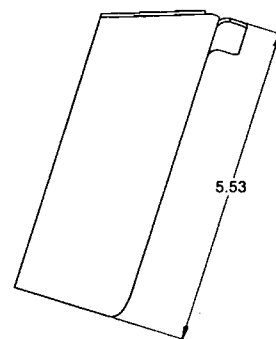
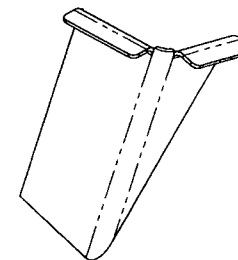
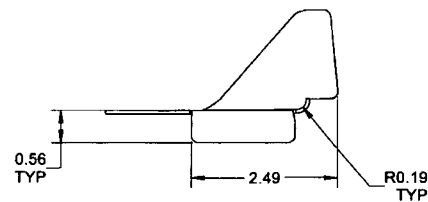
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 4 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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2011-05-20



D4055-5 UPPER CUT OUT

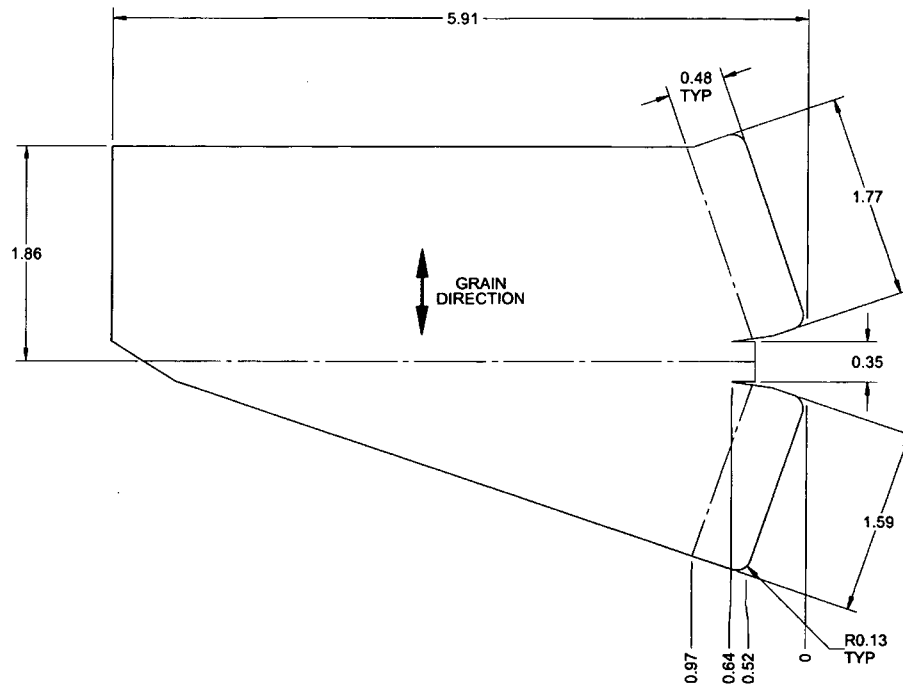
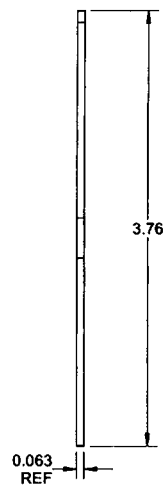
RELEASED
2011-05-30
ANN

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



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MFG. APPR.		D4055	SHEET 8 OF 15
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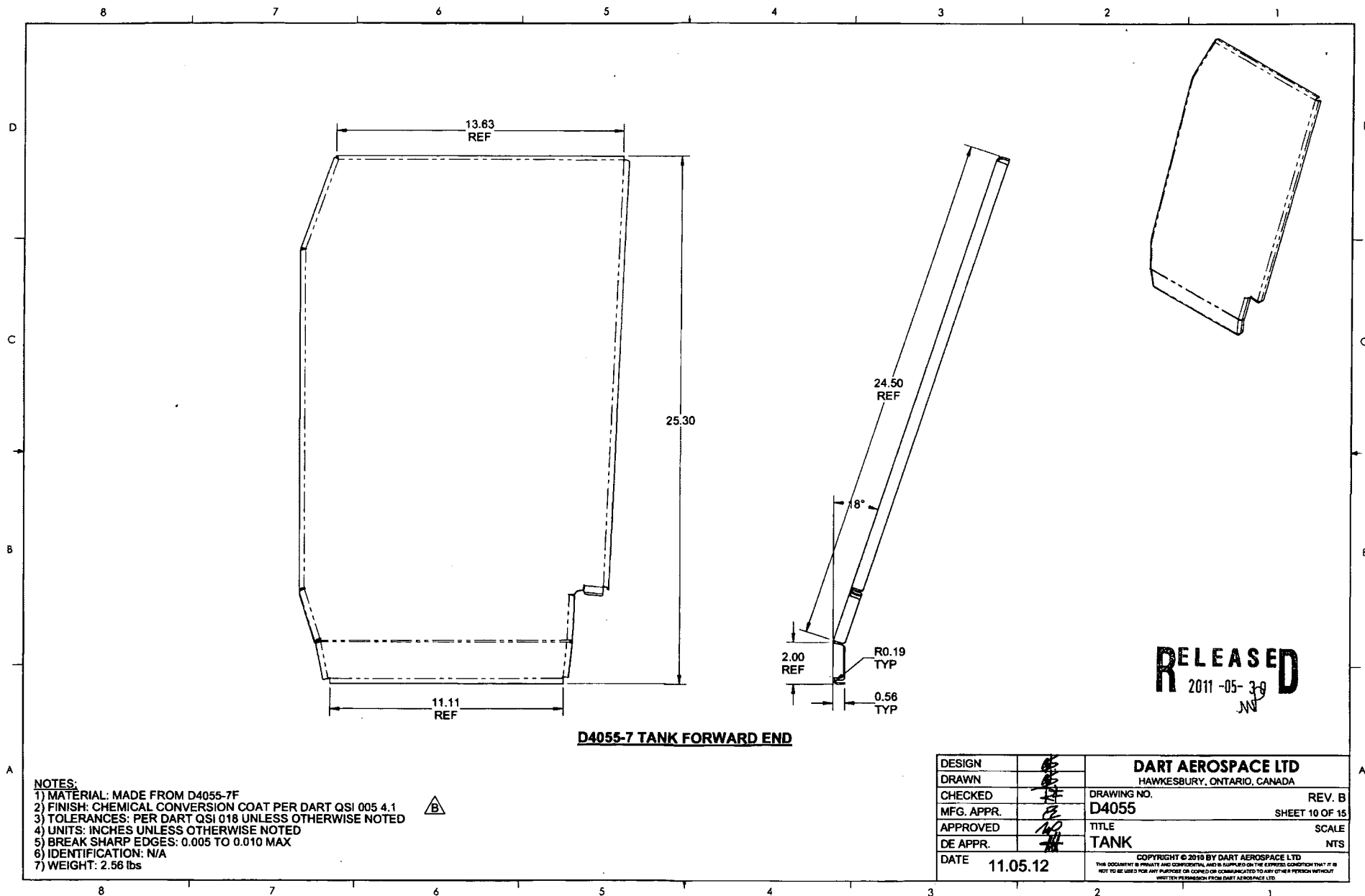
D4055-5F FLAT PATTERN

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2011-05-30

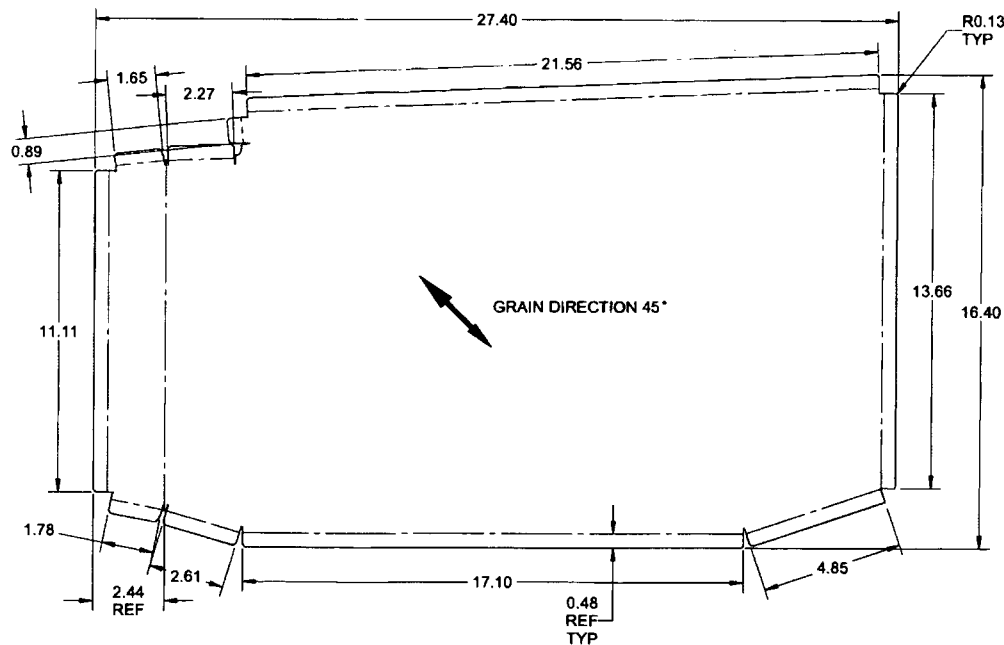
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 9 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK	NTS
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0.063
REF









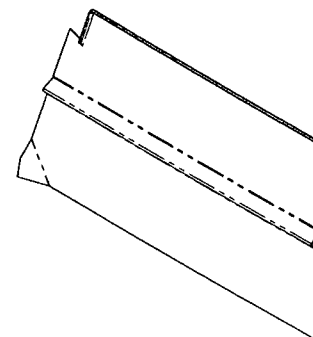
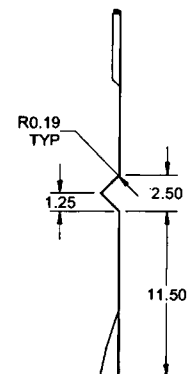
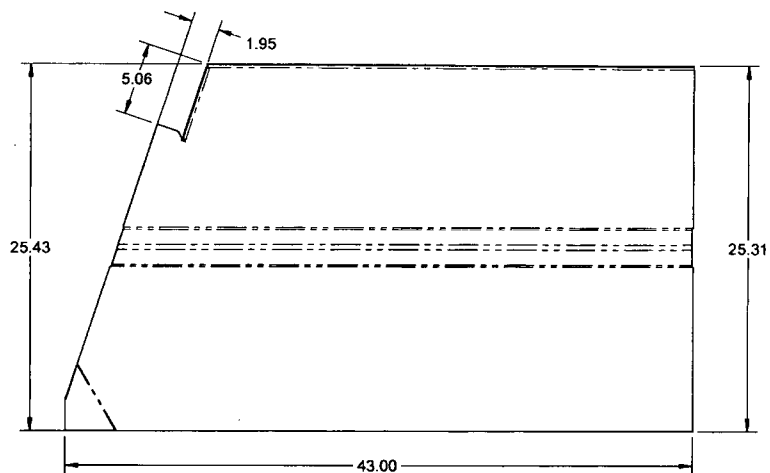
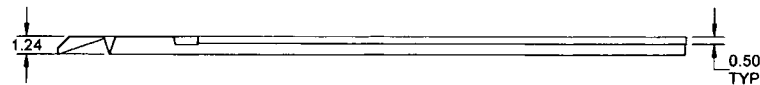
D4055-7F FLAT PATTERN

RELEASED
2011-05-30
JW

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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D4055-9 TANK BACK

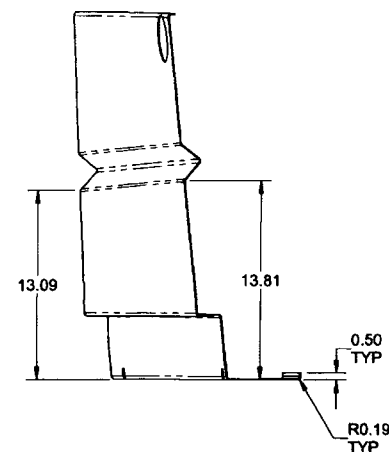
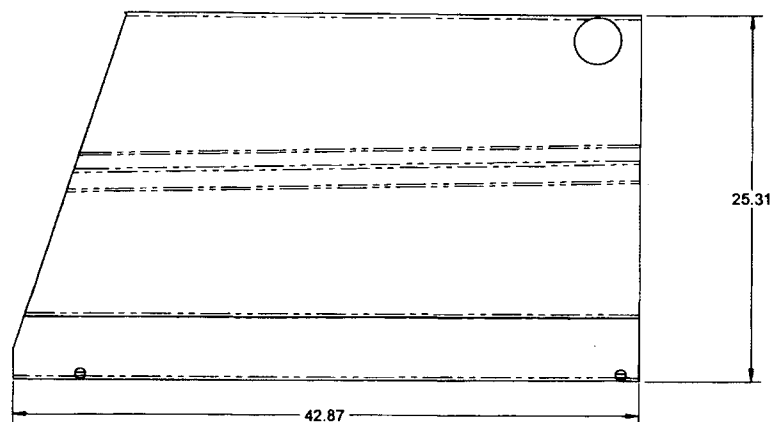
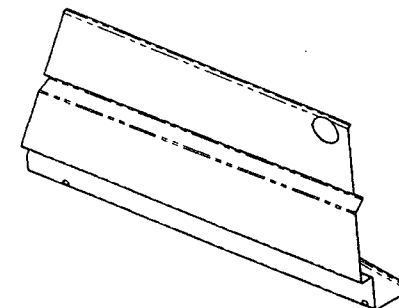
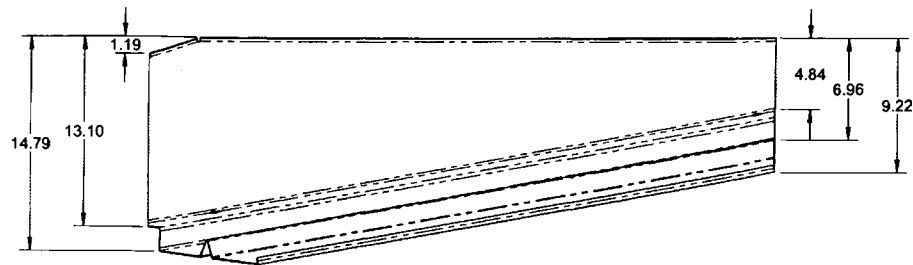
RELEASED
2011-05-30

NOTES:

- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs



DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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D4055-11 TANK FRONT AND BOTTOM

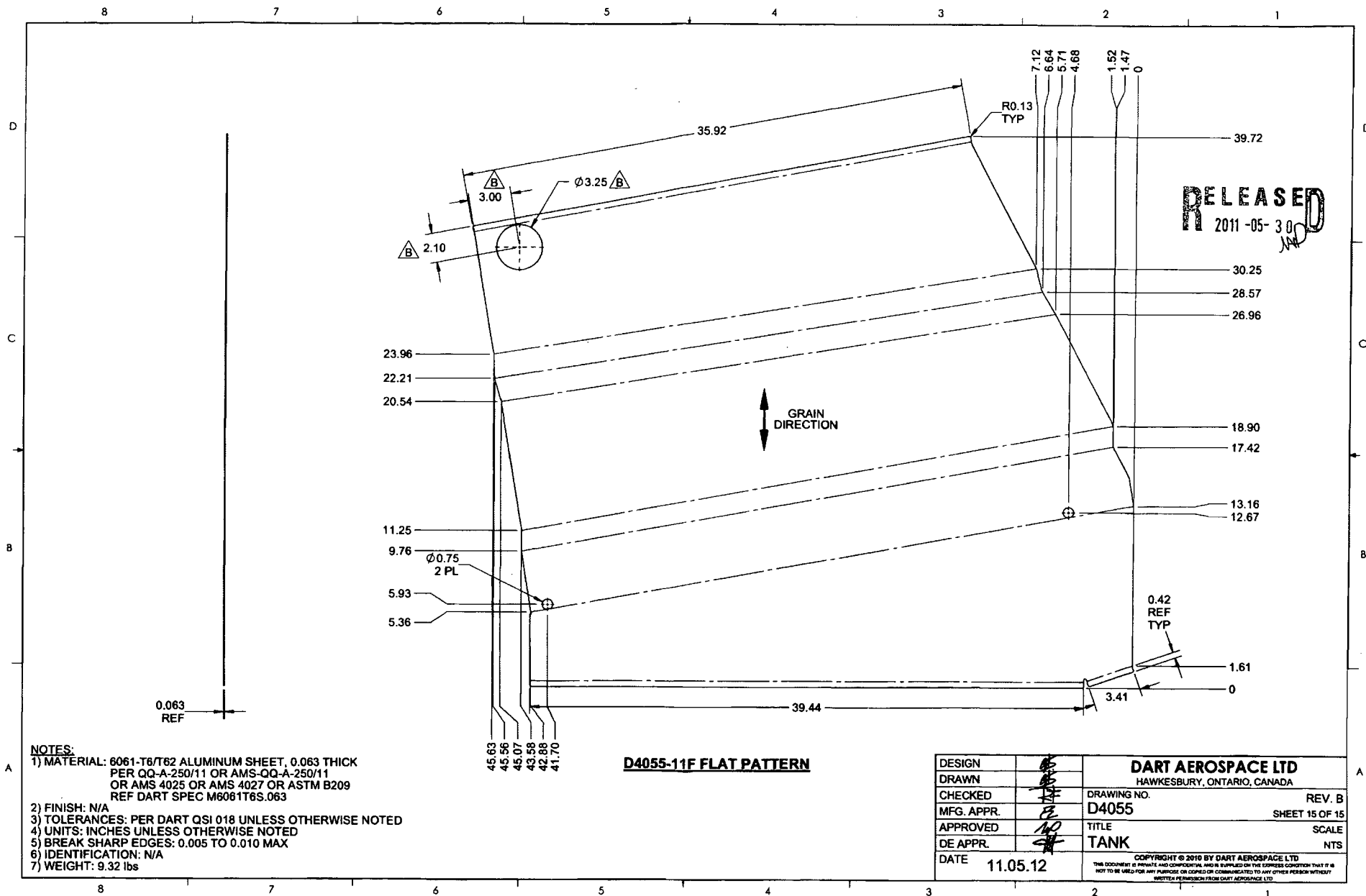
NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D4055	SHEET 14 OF 15
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2011-05-30



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-794 REV. C OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-794 REV. 2 OR EARLIER

REF. TCCA STC: SH05-4
REF. EASA STC: 10031514
REF. BRAZIL STC: 2002S09-07/-08
REF. AUSTRALIAN STC: ASR063SY

PURPOSE:

TO PROVIDE INSTRUCTIONS THAT ALLOW INSTALLATION OF D4404-1/-5/-7/-9 NEOPRENE CUSHIONS TO PREVENT THE D4055-041 AUX. FUEL TANK FROM CHAFING IN SERVICE.

CHANGE:

D350-794-011, D130-794-021, AND D350-794-041 KITS AT CHG 005 OR LATER ARE SUPPLIED TO CUSTOMERS/OPERATORS WITH D4404-1/-5/-7/-9 NEOPRENE CUSHIONS INSTALLED ON D4055-041 AUXILIARY FUEL TANK. CUSTOMERS/OPERATORS WITH D130-794-021 AND D350-794-041 KITS AT CHG 004 AND EARLIER CAN PROCURE DSI-9577-011 KIT FROM DART TO UPGRADE THEIR KITS.

PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9577-011	CUSHION INSTALLATION
1	D4404-1	CUSHION
1	D4404-5	CUSHION, FWD
1	D4404-7	CUSHION, UPPER SIDE
1	D4404-9	CUSHION, LOWER SIDE

INSTALLATION:

INSTALL THE D4404-1/-5/-7/-9 CUSHIONS IN ACCORDANCE WITH FIGURE 1 OF THIS SERVICE INSTRUCTIONS AFTER COMPLETING STEP 5.2.8 OF THE ANNUAL/100 HOUR INSPECTION OF ICA-D350-794 BY APPLYING A THIN, UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP ADHESIVE OR EQUIVALENT). TRIM TO FIT IF REQUIRED.

WEIGHT AND BALANCE:

THE FOLLOWING TABLE LISTS THE NEW WEIGHT AND BALANCE OF THE -011/-021 KITS AT CHG 005 OR LATER OR AFTER DSI-9577-011 KIT HAS BEEN INSTALLED.


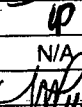

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-794-011 AUXILIARY FUEL TANK (CHG 005) (AS350 MODELS)	32.7 lb 14.8 kg	-22.0 in -0.56 m	-719.4 in-lb -8.29 m-kg	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kg
D130-794-021 AUXILIARY FUEL TANK (CHG 005) (EC130 MODELS)	32.7 lb 14.8 kg	-23.6 in -0.60 m	-771.7 in-lb -8.88 m-kg	126.0 in 3.20 m	4120.2 in-lb 47.4 m-kg

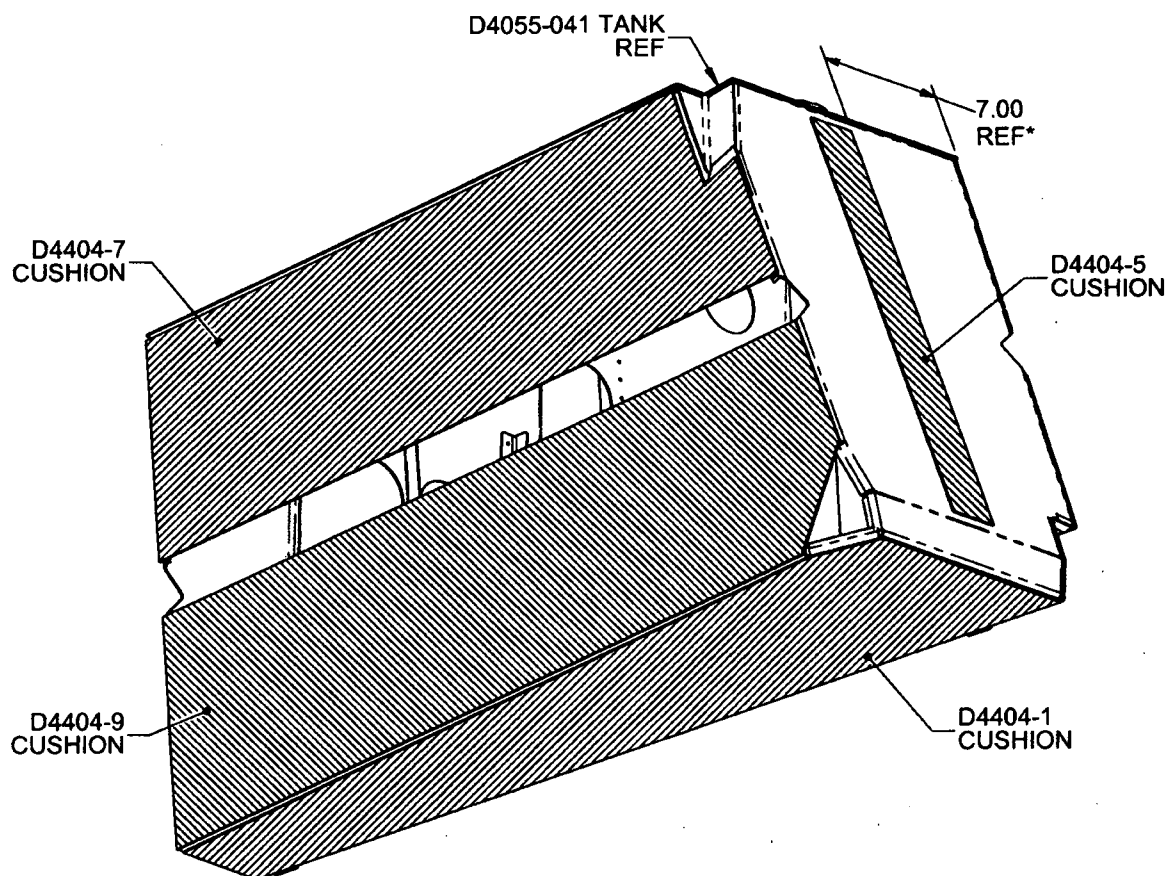
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

A	NEW ISSUE	MB	11.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. REV. A	
MFG. APPR.		DSI 9577 SHEET 1 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		CUSHION INSTALLATION NTS	
DATE 11.10.04		<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



*: ALIGN D4404-5 WITH FORWARD RESTRAINT BEAM (EXISTING ON AS350, D4005-3 ON EC130)

FIGURE 1 - CUSHION INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.10.21
CERT. NO.: SH05-4
ISSUE NO.: 2

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9577	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CUSHION INSTALLATION	NTS
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